Work Orde		746		*11	074	6*							Page 1	ί
Item ID: Revision ID:	D3535-15			Accept	*/	1900	040	100)* s	etup		*N:	S1*	===
	Stainless Steel V	Wearplate Fwd									Stop	*N!	S2*	
Start Date:	1/07/14	Start Qty: 6.00	*6*		(Cust Item I	D:							
Required Date: Reference:	1/07/14	Req'd Qty: 6.00	*6*		(Customer:					`			
Approvals:	Process Plan	: MLJ	Date: 14-01-08	Tooling:		Da	ite:		R		Start	*N	R1*	
	QC:	•	Date:	SPC (Y/N):		Da	ite:				Stop	*N	R2*	
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
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D3535	Rev I	3												
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100		FLOW WATER JET		0.00					_6_	(ر:		AR	
Waterjet FLOW CNC Waterj	et	Memo 1-Cut as pe Deburr if no		0.00 Prog Rev:	3 _2-								14.01	'· 3
110		QC2- Inspect parts off r	nachine FAI/FAIB	0.00			-ii						•	
110									_6_				Ac	
QC Quality Control		Мето		0.00					_	_			14.01	· 3c
				0 2 9	AS 27 891									
120		QC8- Inspect parts - sec	cond check	0.00	1/21									
120				791	NDI				_6_					
QC		Memo		0.00										

Quality Control

DQA:			Date:			WORK ORDER NON-	.cc	NIEOI	DMARICE / II	DDATE					DART
QA Closed:			Date:			WORK ORDER NOW		JINFOI	MINIMINE / O		Wo	ork Order up	date only	1	AEROSPACE
Work Orde	ır.					DISPOSITION				AGAINST I	DEF	PARTMENT	PROCESS		
WOIK OIGE	-					Rework			Skid-tube	Crosstube	\neg		Water Jet	∃ En	gineering
Part N	lo.					Scrap			Machining	Small Fab	ᅦ	Pro	d. Eng. Coor.	1	Quality
NCR N	- lo					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplier		Other
Root					Desc	ription of work order update		nitial	Act	tion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription		Date	Verification	(QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved															
	<u> </u>		1		1		FAI	ULT CA	TEGORY	***				•	
Landi	ng G	Gear				General								_	
		Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspectio Marks/Ch Turning S	nk/Ripple at n Strip in natter	/Wave Tube		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruc Misalia Mislaba Misrea Off-set	ion Incomplete/U tions Incomplete/ gned/off center eled d	· ·		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ci ssing Vrong	Set- Tem Weld	perature/Cure d ng Stock Pulled
		Wave/Tu	ist in Tuk	ne .		Fit/Function		Out of	Sequence		•				

Work Order ID 110746	Wor	k Or	der	ID	110	746
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110746 Page 2 January-07-14 3:02:27 PM Accept Item ID: D3535-15 *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Stainless Steel Wearplate Fwd *6* **Start Date:** 1/07/14 Start Oty: 6.00 **Cust Item ID:** Required Date: 1/07/14 Rea'd Otv: 6.00 **Customer:** Reference: Start Run Date: Tooling: Process Plan: Date: **Approvals:** Stop SPC (Y/N): Date: Date: Reject Reject Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Insp. **Work Center ID Description Run Hours** Code Otv Otv Number Stamp 0.00 130 NC BRAKE *130* 6 DAS Brake NC 0.00 Memo 30 Brake NC 1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT83262-Form 9-89 joggle as per Dwg D3535 using Jig DT81583-Identify as D3535-15 DAS 0.00 QC5- Inspect part completeness to step on W/O 140 *140* 0.00 OC Memo Quality Control Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00 150

150 Powdercoat

Powder Coating

Memo

0.00

FINISH TIME:

6 \$ 14-2-5 353

DQA: Date: V											•			
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			_		AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Orde						DISPOSITION	ĺ		AGAINST	DE	PARTMENT	/PROCESS		
WOIK OIGE	-	···			-	Rework	ı		Skid-tube Crosstube		1	Water Jet	\neg	Engineering
Part N	lo					Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	\dashv	Quality
	-				_	Use-as-is			noforming Finishing	$\overline{}$	1	re/Packaging	┪	Other
NCR N	lo.					Suspected Unapproved			Large Fab Composite	-	,	Supplier	┨	
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Root					Desci	ription of work order update	I	nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	\perp	QC Inspector
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1 a a dia		`~~				Company	FA	ULT CA	TEGORY					
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		Centre No	ot Concor	ntric	-	BOM/Route	┢	Grain	Ogram	\vdash	Over/Under	⊢	_	Set-up
ļ <u> </u>		Cracks	or concer	itiic		Broken/Damage/Defect	-	Hardwa	aro	-	Part Incorre	F	_	Temperature/Cure
	-	Crimp/Kir	nk/Rinnle	/Wave		Burrs		4	ion Incomplete/Unqualified	-	Part Lost/Mi	-	_	Weld
		Cuffs	iky kippic,	, wave		Contamination	\vdash	- i	tions Incomplete/Unclear	\vdash	Part Moved	-	-	Wrong Stock Pulled
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	_	Marks/Ch	•			Drill Holes		Off-set					:	
		Turning S				Finish	F	4	Calibration					
		Wave/Tw				Fit/Function		4	Sequence					·

3								_				
Work Ord January-07-14		0746		*110	746*							Page 3
Item ID: Revision ID: Item Name:	D3535-15 Stainless Stee	l Wearplate Fwd		Accept	*N900	040	100)* s	Setup	Start Stop		S1* S2*
Start Date: Required Date Reference:	1/07/14 e: 1/07/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:	_	_		S44		
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ate:		ŀ	Run	Start	*N	R1*
••			Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*160 *160* QC Quality Control		QC3- Inspect Part Finish Memo		0.00					_//	4.02	.05	9 98-89
170 *170* Packaging Packaging		Identify as per dwg & St Memo	ock Location:	οZ _{0.00}				<u>x (</u>	- 4		<u>U</u>	102/03

180

QC21- Final Inspection - Work Order Release

0.00

1 20

Memo

0.00

Quality Control

MLJ 14-07-05

DQA:	OQA: Date:										7			
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
			•			DISPOSITION			AGAINST	DE	PARTMENT/	PROCESS		
Work Orde	er:						,				1	14/24 2 1 24		- ···
Part N	ام					Rework			Skid-tube Crosstube Machining Small Fab		Dro	Water Jet	\dashv	Engineering Quality
Paili	١٠.					Scrap Use-as-is			noforming Finishing		1	d. Eng. Coor. e/Packaging	-	Other
NCR N	lo.					Suspected Unapproved		IIICII	Large Fab Composite	_	1100/3101	Supplier	\dashv	
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Root					Desci	ription of work order update		nitial	Action		Sign &		П	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification		QC Inspector
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Offset/Setup			:				ļ						1	
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				t			FA	ULT CA	TEGORY		<u> </u>			
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		Bending				Bend		 Folio/I	Program		Outside Dime	ensions	□p	ressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	_]s	Set-up
		Cracks				Broken/Damage/Defect		Hardw	are		Part Incorrec	ί [⊒τ	emperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unqualified		Part Lost/Mis	ssing	\v	Veld
		Cuffs				Contamination			tions Incomplete/Unclear		Part Moved		v	Wrong Stock Pulled
	L	Crushing			· L	Countersink	L	4	gned/off center		Positioned W	· -	_	
	_	Heat Trea				Cut Too Short		Mislab			Power Loss/S	Surge	Ic	Other
		Inspection	-	Tube	ļ	Drawing		Misrea						
		Marks/Ch			\vdash	Drill Holes	ļ	Off-set						
		Turning S			<u> </u>	Finish	-	4	Calibration		•		-	
	•	Wave/Tw	ist in Tub	oe -		Fit/Function		Out of	Sequence					

January-07-14 3:02:26 PM

Work Order ID:

110746

Parent Item:

D3535-15

Parent Item Name:

Stainless Steel Wearplate Fwd

Start Date: 1/07/14

Required Date: 1/07/14

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified Bv:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			100	sf	298.5500	1.0205	6.445263	A	2 14	01.3
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT020		298.55							
				m126	852	7.75							
				m127-	454	290.8			12	7454 -	\longrightarrow		

DQA:	QA: Date:											7	TRAC	
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				 -	AEROSPACE
QA Closed:			Date:				_			W	ork Order up	date only	<u>.</u>	
Work Orde	er:					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS		
	•					Rework	ıl		Skid-tube Crosstub	еГ]	Water Jet	7	Engineering
Part N	No.					Scrap			Machining Small Fa	_	Pro	d. Eng. Coor.	7	Quality
	•				_	Use-as-is			moforming Finishin	g	4	e/Packaging		Other
NCR I	No.					Suspected Unapproved			Large Fab Composit	e]	Supplier		
Root					Desci	ription of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification		QC Inspector
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Handling/Pre	Ш													
Material														
Operator							l			•				
Offset/Setup	Ш													
Process							•		, ·					
Supplier														
Training				1			ļ							
Transport														
Unapproved]											
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	$ldsymbol{ld}}}}}}$	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Se	et-up
		Cracks			_	Broken/Damage/Defect	L	Hardwa	are		Part Incorred	ci _	Te	mperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unqualified		Part Lost/Mi	ssing	w	eld
	L	Cuffs				Contamination		4	tions Incomplete/Unclear		Part Moved	Ļ	w	rong Stock Pulled
		Crushing				Countersink	L	Misali	gned/off center		Positioned V	Vrong	_	
	┕	Heat Trea	at			Cut Too Short		Mislab	eled	L	Power Loss/	Surge	Ot	ther
		Inspectio	n Strip in	Tube		Drawing		Misrea	d ,					· · · · · · · · · · · · · · · · · · ·
		Marks/Ch	natter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order:	110746
Description: Wearshoe	Part Number:	D3535-15
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

D				<u> </u>		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.885	_		V	Ukm-05
2.000	+/-0.010	2.000	-		V	
5.650	+/-0.010	5.650	_		Τ	JKM-06
9.150	+/-0.010	9.150	_		T	
14.400	+/-0.010	14.400	(T	
19.650	+/-0.010	19.650			τ	
24.900	+/-0.010	24.900	•		Т	
30.150	+/-0.010	30.150	_		T	
33.650	+/-0.010	33.650	_		Τ	
35.650	+/-0.010	35.650			7	
39.150	+/-0.010	39,150	-		T	
Ø0.188	+0.005/-0.001	ુછ્ય.	_		>	
24.00	+/-0.030	24.00			T	
16.00	+/-0.030	16.00	_		T	
8.00	+/-0.030	8.00	_		Τ	
5.00	+/-0.030	5.00	_		T	
0.300	+/-0.010	.303	_		V	
0.300	+/-0.010	.302	_		V	
0.038	+/-0.010					
.040	+1- ,010	,036	_		V	

		DAS		
Measured by: Ae	Audited by:	27	Prototype Approval:	N/A
Date: 14 · 01 · 30	Date:	14/11/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.05.10	New Issue	KJ/JLM of	E

CHECKED

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DART

AEROSPACE PORT HADLOCK,

USA,

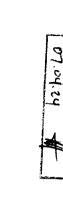
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D3535 DRAWING NO.

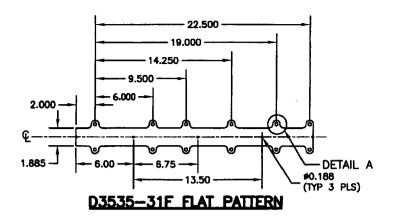


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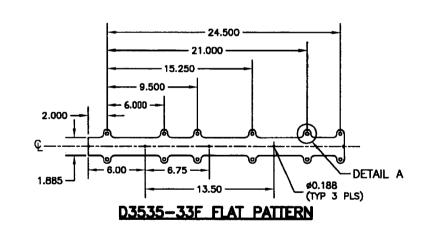
WEARSHOE



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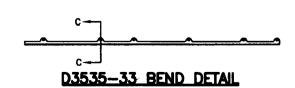
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PURPOSE

OR COPIED

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
 - 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT &
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



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1:10	SCALE	SHEET 4 OF 7	X:V. B

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AEROSPACE PORT HADLOCK,

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USA,

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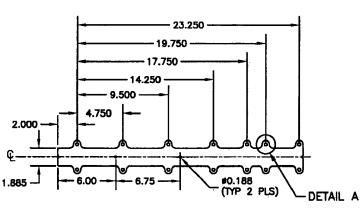
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DRAWING NO

DATE

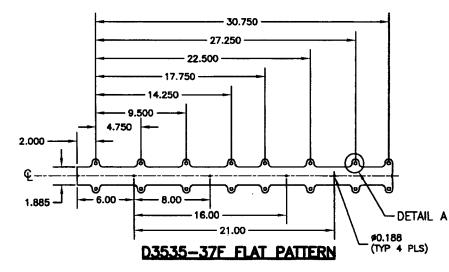
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WEARSHOE



D3535-35F FLAT PATTERN





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PURPOSE

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COPIED

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER

- QSI 005 4.3

 3) PART IS SYMMETRICAL ABOUT €

 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



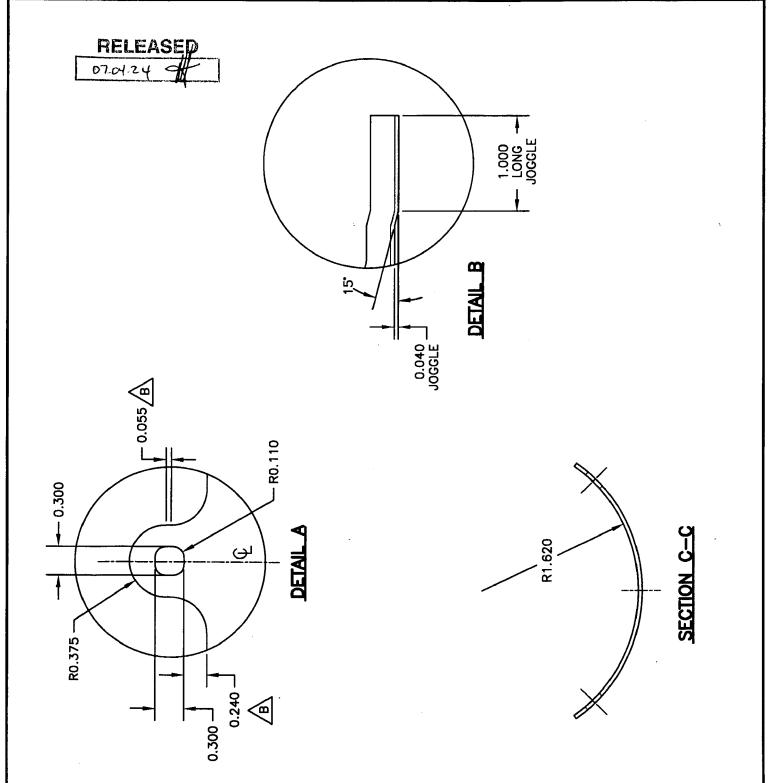
SHEET SCALE 1:10

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REV. B



DESIGN	DRAWN BY	DART	AEROSPACE USA, INC.
CHECKED **	APPROVED #/	DRAWING NO.	REV. B
		D3535	SHEET 7 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:1



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